

Date: Friday, 11/17/2006 9:08:05 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STEP (CASTING DETAIL)		
Job Number	: 29514		Part Number	: D25761		
Estimate Number	: 11088		Drawing Number	: D2576 REV E1		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 11/17/2006 S.O. No. : N/A		Drawing Revision	: E1		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 11/30/2006 Qty: 100 Um: Each		
Previous Run	: N/A		Type	: PURCHASED PARTS		
Written By	:					
Checked & Approved By	:					
Comment	: Est Rev: A New Issue 05-11-29 JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING  <span style="margin-left: 150px;">c Loc 11117</span> <span style="margin-left: 550px;">100</span>
<b>Comment:</b> PURCHASING Issue P/O: <u>2509</u> Ship D2576 mould to vendor Cast per D2576-1 Pattern Material Release Note Required		
2.0	D25761P	Step (Casting Detail)  <span style="margin-left: 550px;">100</span>
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s) STEP		
3.0	PACKAGING 1	PACKAGING RESOURCE #1  <span style="margin-left: 550px;">100</span>
<b>Comment:</b> PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure D2576 mould is returned with the ordered parts Ensure release note is attached		
4.0	QC6	DIMENSIONAL CHECK  <span style="margin-left: 550px;">100</span>
<b>Comment:</b> DIMENSIONAL CHECK		
5.0	PACKAGING 1	PACKAGING RESOURCE #1  <span style="margin-left: 550px;">100</span>
<b>Comment:</b> PACKAGING RESOURCE #1 Identify and Stock Location: <u>ST177 ws</u> <span style="margin-left: 150px;">Loc 9/12/00 (100)</span>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/12/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: STEP (CASTING DETAIL)

Job Number: 29514

Part Number: D25761

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



100

Comment: FINAL INSPECTION/W/O RELEASE

11/06/12/04

Job Completion



11/06/12/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



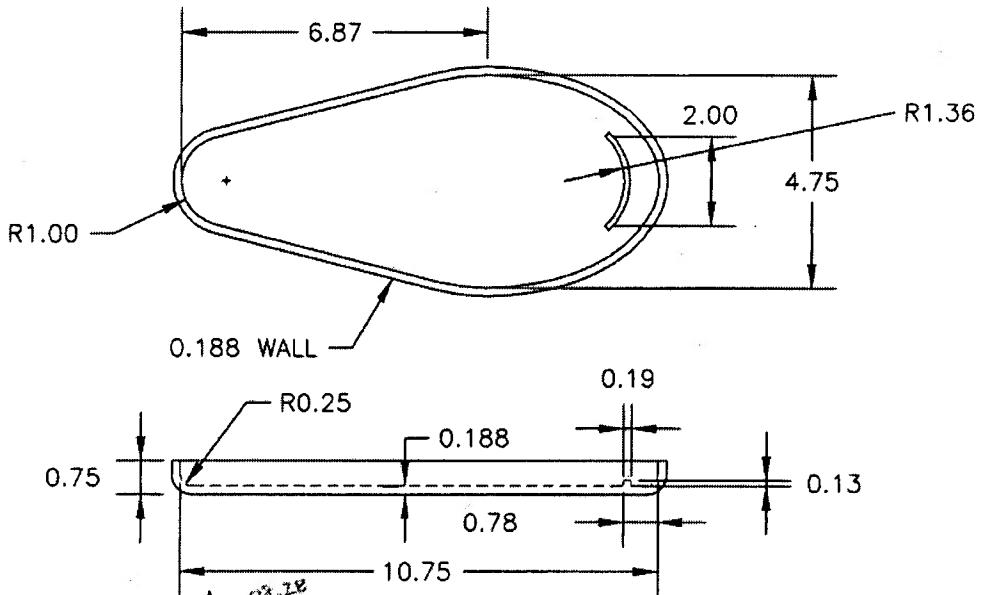
DO COPY IS  
DART

DESIGN <i>RF</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKSBURY, ONTARIO, CANADA
CHECKED <i>RF</i>	APPROVED <i>KE</i>	DRAWING NO. D2576
DATE 99.09.07		REV. E SHEET 1 OF 1
		SCALE 1:1

RELEASER  
99.09.08 DS

CASTING DETAIL (D2576-1) (P<sub>00</sub> B<sub>28</sub>)

MATERIAL: CAST ALUMINUM ALLOY A-535.2  
BREAK SHARP EDGES 0.025 TO 0.050  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES



MACHINING DETAIL (D2576-3) (P<sub>00</sub> B<sub>28</sub>)

D 0.250 X 0.65 SLOT  
(4 PLACES)  
IN APPROX. LOCATION SHOWN

0.063 POCKET (LEAVE 0.125)

0.250 X 1.28 SLOT D

IT IS ACCEPTABLE TO OPEN  
THIS HOLE 0.125 IN EITHER  
DIRECTION AS SHOWN  
FOR WELDING

Copyright 1996 by DART AEROSPACE LTD

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 29514

**ALPINE NON-FERROUS FOUNDRY**  
8657-132ND STREET  
SURREY, B.C. V3W 4P1

**WORK ORDER**

Tel: (604) 596-8080      Fax: (604) 596-8045

**Sold To:** DART AEROSPACE  
1270 ABERDEEN STREET  
HAWKESBURY, ONT  
CANADA K6A 1K7

**Ship To:** DART AEROSPACE

Order Date	Purchase Order#	Due Date	Ship Via		Page
17-Nov-2006	PO0002509	29-Nov-2006	FEDEX		1
Item#	Item Code	Description	Material	Ordered	Ship
1	DART D2576	D2576 STEP CSTG		100	100
2		DB 06/11/27			

**Comments**

Castings&Patterns are property of Alpine until paid in full

Nov 27/06

# CERTIFICATE OF ANALYSIS

CUSTOM ALLOY LIGHT METALS  
13329 ECTOR STREET CITY OF INDUSTRY, CA 91746  
PH# (626) 369-3641 FAX# (626) 369-2471

**CUSTOMER:**

RYPAC ALUMINUM  
11849 TANNERY ROAD  
SURREY BRITISH COLUMBIA,

**SHIP DATE****NOV 06 2006****CONFORMS TO ASTM SPECIFICATION: B179-03**

Alloy: 535.2

Heat: G862

Si	0.044
Fe	0.074
Cu	0.001
Mn	0.131
Mg	6.770
Cr	0.001
Zn	0.003
Ti	0.167
Sn	0.003
Pb	0.001
Ni	0.001
OET	< .15
Sr	0.000
Al	REMAINDER

Si	.10
Fe	.10
Cu	.05
Mn	.10-.25
Mg	6.6-7.5
Cr	
Zn	.05
Ti	.10-.25
Sn	
Pb	
Ni	
OET	.15
Sr	
Al	REMAINDER

BE .004

BE .003-.007

ELEMENTS LISTED WITHOUT A RANGE, UNDER THE REQUIRED SPECIFICATIONS, ARE MAXIMUM ALLOWABLE PERCENTAGES. SAMPLES ANALYZED ON AN OPTICAL EMISSION SPECTROMETER WITH CURRENT CALIBRATION STATUS. STANDARDS ARE NIST OR ARE TRACEABLE TO NIST.

NOV 06 2006

RON ZAKRZEWSKI

DATE

LAB MANAGER

FM-12.01 Rev D 12/5/2001

WARNING: THE BUYER IS ADVISED THAT THIS METAL MAY CONTAIN CREEVICES AND HIDDEN RECESSES HOLDING ENTRAPPED MOISTURE. THE METAL SHOULD BE HANDLED AND PROCESSED WITH THIS POSSIBILITY IN MIND. ENTRAPPED MOISTURE MAY CAUSE AN EXPLOSION IF THE METAL IS INTRODUCED INTO A MELTING FURNACE WITHOUT PROPER DRYING.